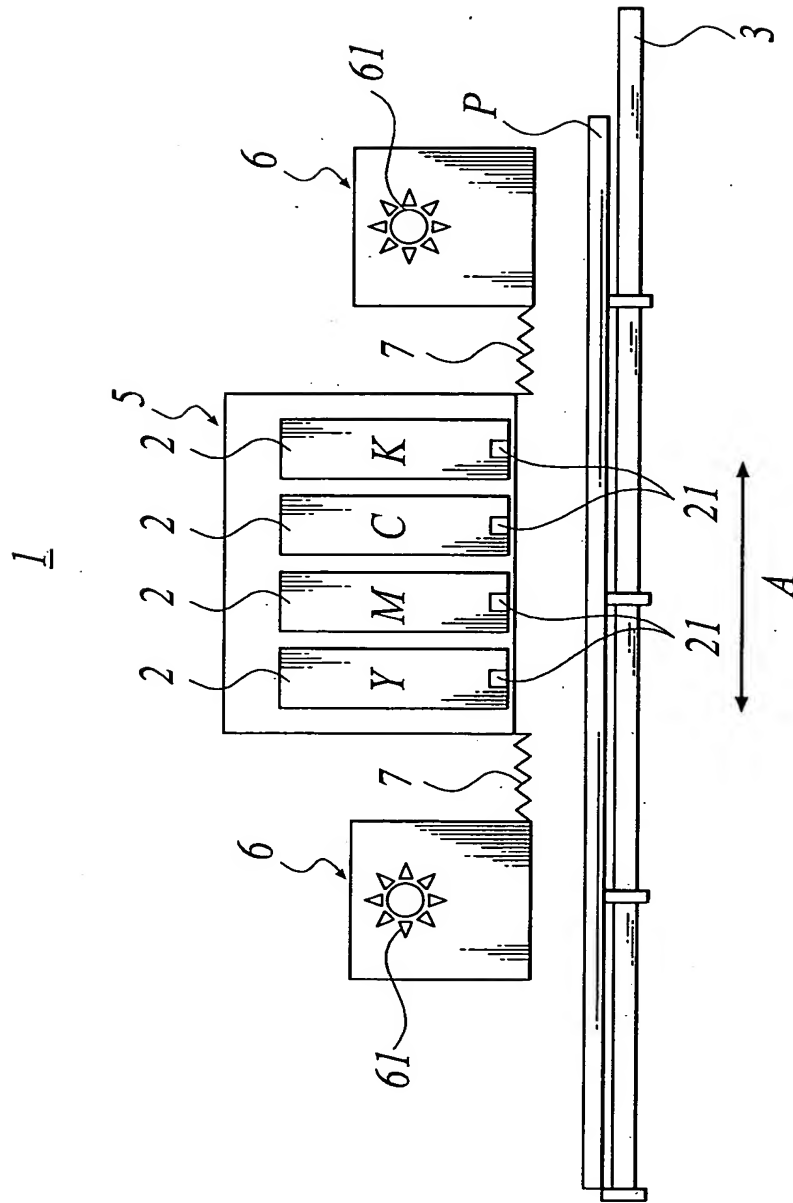


FIG 1



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FIG.2

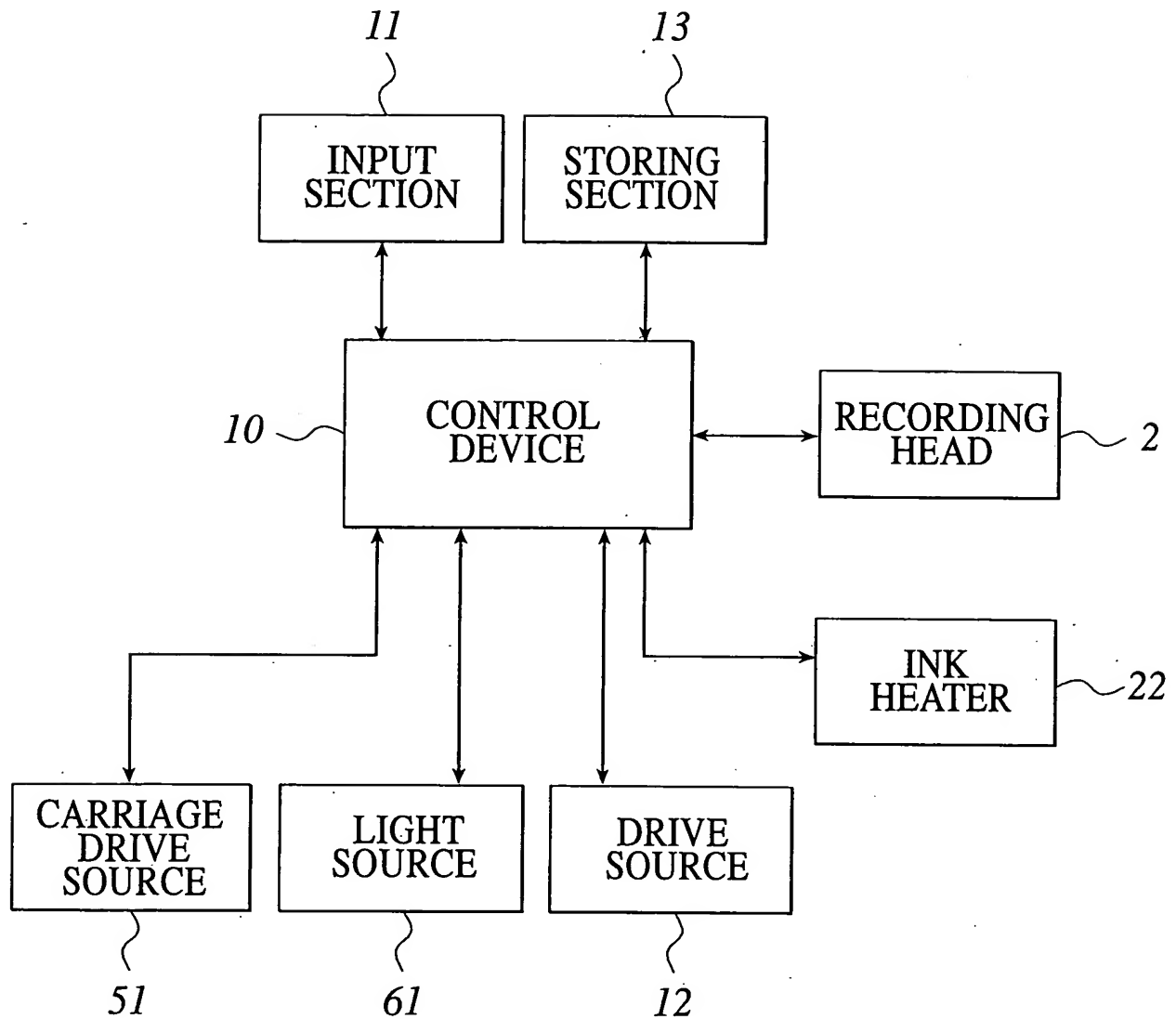


FIG.3A

SERIAL PRINT TYPE

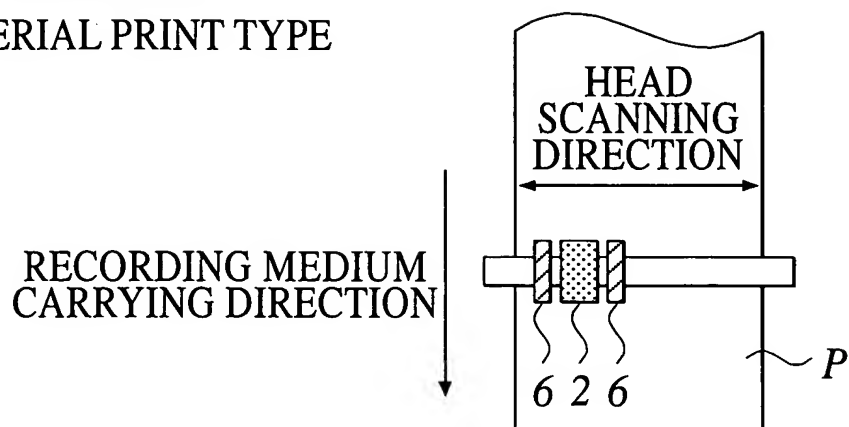


FIG.3B

LINE HEAD TYPE

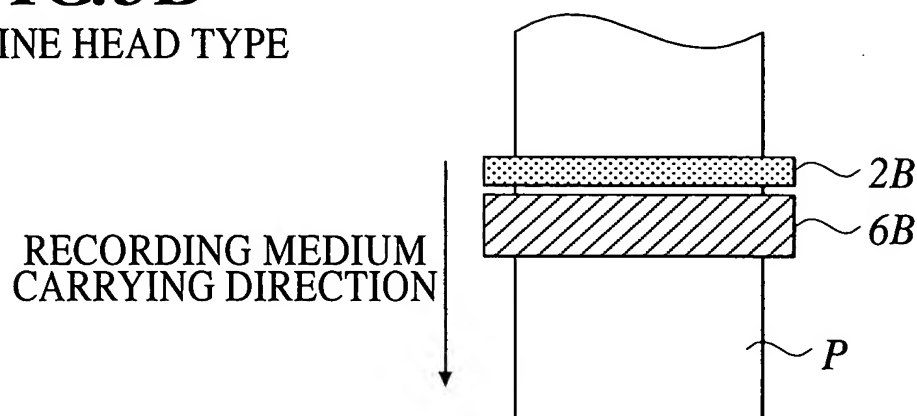


FIG.3C

FLAT BED TYPE

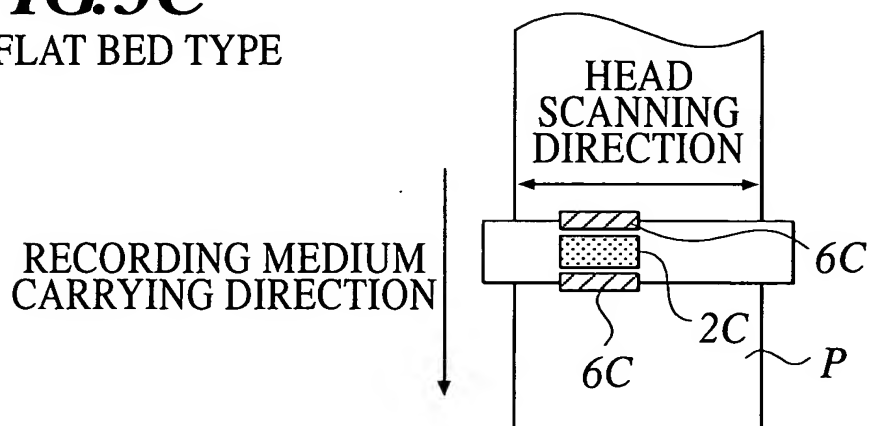


FIG.4

INK COMPOSITION(% BY MASS)						
INK TYPE	COLOR MATERIAL		PHOTO POLYMERIZABLE COMPOUND			INITIATOR
	TYPE	ADDITION AMOUNT	EPOXY COMPOUND	OXETANE COMPOUND		
			CELOXIDE2021P	OXT-221	OXT-212	
K	COLOR MATERIAL 1	5.0	15.0	40.0	35.0	5.0
C	COLOR MATERIAL 2	2.5	17.5	45.0	30.0	5.0
M	COLOR MATERIAL 3	3.0	17.0	45.0	30.0	5.0
Y	COLOR MATERIAL 4	2.5	17.5	45.0	30.0	5.0

FIG.5

RECORDING CONDITION	RESOLUTION (dpi)	NUMBER OF PASS	AMOUNT OF INK DROPLET (pl/pixel)	LIMIT AMOUNT OF INK	MAXIMUM AMOUNT OF INK ADHESION (4 COLORS SOLID AREA ml/m ²)	CARRIAGE SPEED (mm/s)	INK BLURRING	ADHESIVENESS TO BASE MATERIAL	WRINKLE
1	720	8	8	400%	23.6	280	A	A	A
2	720	8	12	400%	35.4	280	B	C	C
3	720	8	12	250%	22.1	280	A	A	A
4	720	4	8	400%	23.6	280	B	C	C
5	720	4	8	250%	14.8	280	A	B	A
6	360	4	28	400%	22.4	95	A	A	A
7	360	2	28	400%	22.4	95	C	C	C
8	360	2	28	300%	16.8	95	B	A	A

FIG.6

RECORDING CONDITION	RESOLUTION (dpi)	NUMBER OF PASS	AMOUNT OF INK DROPLET (pl/pixel)	LIMIT AMOUNT OF INK	MAXIMUM AMOUNT OF INK ADHESION (4 COLORS SOLID AREA ml/m ²)	CARRIAGE SPEED (mm/s)	INK BLURRING	ADHESIVENESS TO BASE MATERIAL	WRINKLE
1B	360	1	28	400%	22.4	200	B	A	A
2B	360	1	28	400%	22.4	300	C	C	C
3B	360	1	28	250%	14	300	A	A	A

FIG.7

RECORDING CONDITION	RESOLUTION (dpi)	NUMBER OF PASS	AMOUNT OF INK DROPLET (pl/pixel)	LIMIT AMOUNT OF INK	MAXIMUM AMOUNT OF INK ADHESION (4 COLORS SOLID AREA ml/m ²)	CARRIAGE SPEED (mm/s)	INK BLURRING	ADHESIVENESS TO BASE MATERIAL	WRINKLE
1C	720	8	28	400%	35.4	200	B	A	A
2C	720	4	28	400%	35.4	200	C	C	C
3C	720	4	28	250%	22.1	200	A	A	A